

Work Order ID 67362

Wednesday, March 16, 2011 12:34:18 PM



Page 1

Item ID: D119-675-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 3/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-03-16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675011 CHG003

8 11/15/11

11-4-26

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/26 SP (40)

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 11/15/11

44

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D119-675-011

Revision ID:

Item Name: Heli-Access-Step LH

Start Date: 3/16/2011 Start Qty: 4.00

Required Date: 3/16/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PRP D119-675-011
Location: _____

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/11 4

11/5/11

MF

A-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 67362

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH





Start Date: 3/16/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP RevE change at rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3043-041 		Manufactured	No			110	Each	0.0000	1	4	67362		
Step Weldment LH, A119 D2182B032 		Manufactured	No			120	Each	20.0000	4	16	4.2640		
Rubber Cushion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		20							
				63469		20							
D2274 		Manufactured	No			120	Each	396.0000	8	32	367578		
Radius Block													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		396							
				61361		1							
				63990		6							
				65562		16							
				65757		250							
				66123		123							
D2617-3 		Manufactured	No			120	Each	41.0000	4	16	11/4/07		
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST019		41							
				52651		41							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67362

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 3/16/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2617-5 Manufactured No 120 Each 14.0000
Spacer

8 32 18x
B67360 SP 11/4/26

Location Loc Qty Loc Code

ST019 14
66157 14

D2732 Manufactured No 120 f 481.6373 1.066
Rubber Extrusion

14
4.264
SP

Location Loc Qty Loc Code

ST410 472.75
64283 472.75
ST412 8.887279
56516 8.887279

D3041-1 Manufactured No 120 Each 16.0000
Clamp

4 16 4x
B677790 SP

Location Loc Qty Loc Code

ST463 16
65638 16

D3041-3 Manufactured No 120 Each 10.0000
Clamp

2 8
11/4/26 SP (4)

Location Loc Qty Loc Code

ST463 10
51114 2
65639 8

2
6

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67362

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 3/16/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3042-1
Clamp

Manufactured No

120 Each

15.0000

4

16



(1X)
B67402

Location

Loc Qty

Loc Code

ST457

15

48241

15

120

Each

234.0000

4

16



15
16

AN4-11A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

234

110382

34

115316

200

120

Each

226.0000

8

32



16
32

AN4-12A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

226

112314

26

115371

40

115422

160

120

Each

310.0000

4

16



32
16

AN4-15A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST308

296

116786

296

ST358

14

114784

9

115108

5

16

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67362

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH



Start Date: 3/16/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 . NAS1149D0463J Purchased

No

120

Each

30.0000

12

48



Washer



11/70658

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

MS21042L4

Purchased

No

120

Each

4,219.000

12

48



Nut



11/2658

Location

Loc Qty

Loc Code

ST300

4219

1123143

2

115589

10

115621

20

116188

2187

116823

2000

48

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™</i> , LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™</i> , RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

